

Date: Thursday, 1/17/2008 3:32:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 36856	
Estimate Number : 10349	
P.O. Number :	Part Number : D28582
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D2858 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 36628	Material :
Written By :	Due Date : 2/10/2008 Qty: 24 Um: Each
Checked & Approved By : <u>08 01 18</u>	
Comment : Est C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)
 Material: 1.50" X 1.25"
 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)
 (M6061T6B15001250
 Batch 01104183

ml 08/02/12

24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

ml 08/02/12

24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2858-2

JL 08/02/15

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:32:06 PM
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Drawing Name: HINGE BRACKET

Job Number: 36856

Part Number: D28582

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/02/15

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SF 08/02/19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/19 (24)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

BR 08-02-19 (24)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M10700 S

m-l 08/02/19 (24X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

08-02-19 (24X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S2

8/2/19 SP (24X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/20 (24)

Job Completion



min 2008/2/20

W

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36856
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.171	✓			
Ø0.400	+0.005/-0.000	.400	✓			
R0.125	+/-0.010	.125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.819	✓			
1.476	+/-0.010	1.477	✓			
0.342	+/-0.010	.342	✓			
0.875	+/-0.010	.875	✓			
1.56	+/-0.030	1.564	✓			
0.147	+/-0.010	.149	✓			
0.717	+/-0.010	.722	✓			
0.697	+/-0.010	.695	✓			
0.229	+/-0.010	.233	✓			
R0.125	+/-0.010	.125	✓			
R0.063	+/-0.010	.063	✓			
0.063	+/-0.010	.062	✓			
0.126	+/-0.010	.126	✓			
0.630	+/-0.010	.627	✓			
R0.354	+/-0.010	.354	✓			
0.965	+/-0.010	.969	✓			
Ø0.166	+0.005/-0.000	.168	✓			

Measured by:	J.L.	Audited by:	J.F.	Prototype Approval:	N/A
Date:	08/02/15	Date:	08/02/15	Date:	N/A

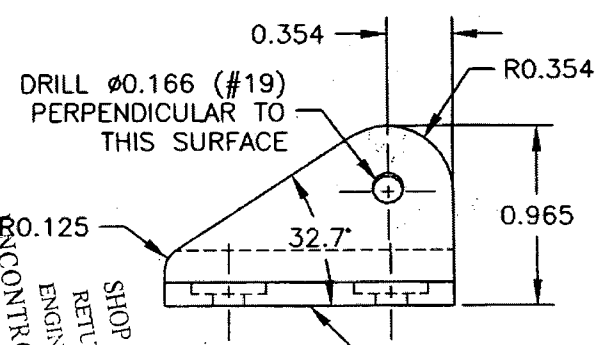
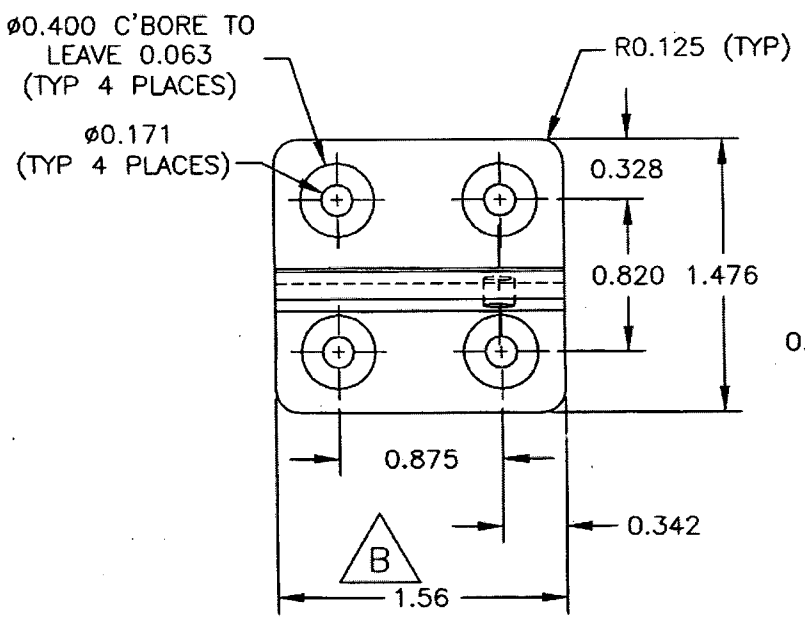
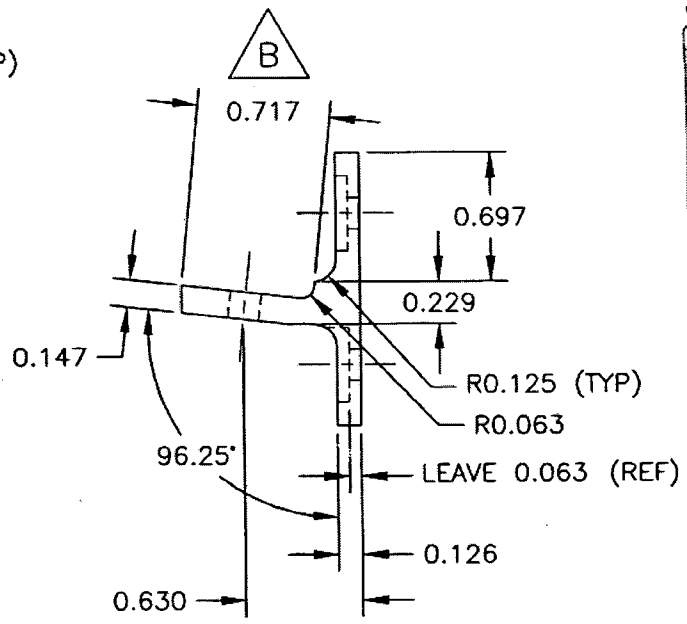
Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	<i>[Signature]</i>

DART



RELEASED
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
VE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	KE	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	98.12.14	SCALE
B	99.02.28	1:1
	0.717 WAS 0.667, 1.56 WAS 1.559	



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36850
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
36850